

7075 φ2.0

Work Order ID 110602

Friday, January 03, 2014 10:08:38 AM

110602

Page 1

Item ID: PB67-43001-293**Accept*****N9000040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Extension Tube Adjustment Fitting**Start Date:** 1/3/2014 **Start Qty:** 8.00***g*****Cust Item ID:****Required Date:** 1/31/2014 **Req'd Qty:** 8.00***g*****Customer:****Reference:****Approvals:****Process Plan:** MF**Date:** 14-01-03**Tooling:****Date:****Run Start*****NR1*****QC:****Date:****SPC (Y/N):****Date:****Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp****Draw Nbr****Revision Nbr**

B67-43001

C

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA 552 & Dwg B67-43001

Test fit on knurling Jig DT9423

S/D 14-2-6

11

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S/D 14-2-6

11

140

0.00

140

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

FK 14/02/07

11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 110602

Friday, January 03, 2014 10:08:38 AM

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Page 2

Item ID: PB67-43001-293

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Extension Tube Adjustment Fitting

Start Date: 1/3/2014 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	Mask threaded section and inside bore START TIME: 9:00 OVEN TEMPERATURE: 320° FINISH TIME: 9:30								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

11 MG 14-2-7

11 φ 14-2-8 DAS 34 989

DAS
17
9:39
14/2/11

11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
Transport									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Item ID: PB67-43001-293

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Extension Tube Adjustment Fitting

Start Date: 1/3/2014 Start Qty: 8.00 ***8***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Identify as per dwg & Stock Location: Mezz. 2 0.00***180***

Packaging

Memo

0.00

Packaging

11x DAS
28 14-02-11
9-89

190

QC21- Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

14-02-1314-02-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

Friday, January 03, 2014 10:08:37 AM

Page 1

Work Order ID: 110602

Parent Item: PB67-43001-293

Start Date: 1/3/2014

Required Date: 1/31/2014

Parent Item Name: Extension Tube Adjustment Fitting

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.08.29New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6R2.000 7075 RD bar 2.00		Purchased	No			100	f	3.0930	0.15	2			

Location

Loc Qty

Loc Code

MAT012

3.093

108595

3.093

2 JFC 2014-01-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

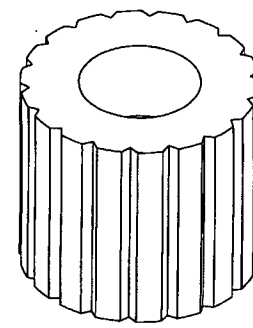
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TAS 1.508



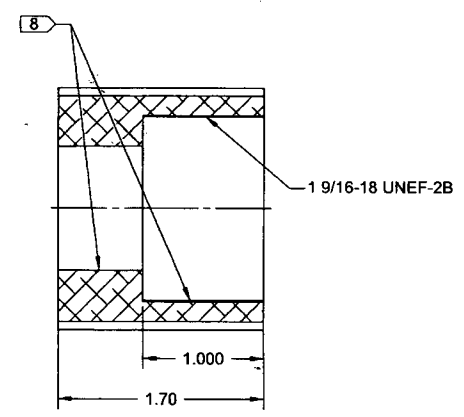
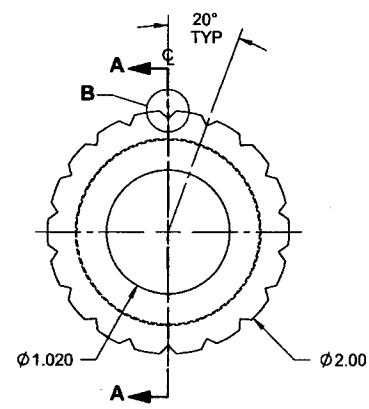
mf
#110600
14-a-03

RELEASED
2009-09-24

B67-43001-293 EXTENSION TUBE ADJUSTMENT FITTING

NOTES:

- 1) MATERIAL: 7075-T6 (OR 7075-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4124/4186/4187) OR
PER AMS-QQ-A-200/11
REF. DART SPEC. M7075T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.28 lbs
- 8) MASK HOLE AND THREADS PRIOR TO PAINTING



SECTION A-A

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. REPLACED INEFFECTIVE KNURL WITH GROOVES (PER DETAIL B). FOR PREVIOUS REVISIONS, REFER TO PAGE 38 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.26
	REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	ASS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-293	SHEET 1 OF 1	
APPROVED	MB	TITLE	SCALE	
DE APPR.	N/A	EXTENSION TUBE ADJUSTMENT FITTING	NTS	
DATE	09.02.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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